

WHAT IS CLAIMED IS:

1. A coated article comprising:
 - a glass substrate;
 - a layer comprising tin oxide provided on and contacting a surface of the glass substrate;
 - a layer comprising silicon nitride provided on and contacting the layer comprising tin oxide;
 - an infrared (IR) reflecting layer located on the substrate over the layer comprising tin oxide and over the layer comprising silicon nitride; and
 - a dielectric layer provided on the substrate over at least the IR reflecting layer.
2. The coated article of claim 1, wherein the IR reflecting layer comprises at least one of NiCr, Cr, Ni, Ag, Nb, and NbZr, and wherein a combined thickness of the layer comprising tin oxide and the layer comprising silicon nitride is from 700 to 900 Å and wherein the coated article has blue glass side reflective color.
3. The coated article of claim 1, wherein the dielectric layer located over at least the IR reflecting layer comprises silicon nitride.
4. The coated article of claim 1, wherein the coated article is heat treated.
5. The coated article of claim 1, wherein the IR reflecting layer is in direct contact with the layer comprising silicon nitride.

6. The coated article of claim 1, wherein the coated article is one of a monolithic window unit, an insulating glass (IG) window unit, and a laminated vehicle windshield.
7. The coated article of claim 1, wherein the layer comprising tin oxide further comprises nitrogen.
8. The coated article of claim 1, wherein the layer comprising silicon nitride further comprises from 1 to 12 % aluminum.
9. The coated article of claim 1, wherein the coated article has a visible transmission from about 6 to 80%.
10. The coated article of claim 1, wherein the coated article has a visible transmission of from about 10-50%.
11. The coated article of claim 1, wherein the coated article has a sheet resistance (R_s) of less than 250 ohms/square.
12. The coated article of claim 1, wherein the coated article has a sheet resistance (R_s) of less than 100 ohms/square.

13. The coated article of claim 1, wherein the coated article includes a multi-layer coating consisting essentially of the layer comprising tin oxide, the layer comprising silicon nitride, the IR reflecting layer, and the dielectric layer.

14. The coated article of claim 1, wherein the coated article has no infrared (IR) reflecting layer comprising significant amounts of Ag or Au.

15. A heat treated coated article comprising:
a glass substrate;
a layer comprising tin oxide supported by the glass substrate and being located beneath any and all IR reflecting layer(s) of the coated article;
a layer comprising silicon nitride provided on and contacting the layer comprising tin oxide;
an infrared (IR) reflecting layer located over the layer comprising tin oxide and over the layer comprising silicon nitride; and
a dielectric layer provided on the substrate over at least the IR reflecting layer.

16. The coated article of claim 15, wherein the IR reflecting layer comprises at least one of NiCr, Cr, Nb, and NbZr.

17. The coated article of claim 15, wherein the dielectric layer located over at least the IR reflecting layer comprises silicon nitride.

18. The coated article of claim 15, wherein the IR reflecting layer is in direct contact with the layer comprising silicon nitride.

19. The coated article of claim 15, wherein the layer comprising tin oxide further comprises nitrogen.

20. The coated article of claim 15, wherein the coated article has a sheet resistance (R_s) of less than 250 ohms/square, and wherein a combined thickness of the layer comprising tin oxide and the layer comprising silicon nitride is from 700 to 900 Å.

21. The coated article of claim 15, wherein the coated article has no infrared (IR) reflecting layer comprising significant amounts of Ag or Au.

22. A method of making a coated article, the method comprising:
sputtering a layer comprising tin oxide on a glass substrate;
sputtering a layer comprising silicon nitride on and in contact with the layer comprising tin oxide;
sputtering an IR reflecting layer over the layer comprising tin oxide and over the layer comprising silicon nitride; and
sputtering a dielectric layer over the IR reflecting layer.

23. The method of claim 22, wherein a combined thickness of the layer comprising tin oxide and the layer comprising silicon nitride is from 700 to 900 Å, and wherein the coated article has blue glass side reflective color.

24. A heat treated coated article comprising:

- a glass substrate;
- a layer comprising tin oxynitride supported by the glass substrate and being located beneath any and all IR reflecting layer(s) of the coated article;
- a layer comprising silicon nitride provided on and contacting the layer comprising tin oxynitride;
- an infrared (IR) reflecting layer located over the layer comprising tin oxynitride and over the layer comprising silicon nitride; and
- a dielectric layer provided on the substrate over at least the IR reflecting layer.